Date: Thursday, 4/12/2007 8:29:00 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI UTILITY BASKET LH/RH
Job Number	: 31675		
Estimate Number	: 10197		
P.O. Number	: N/A	Part Number	: D350607041
This Issue	: 4/12/2007 S.O. No. : N/A	Drawing Number	: D350-607 REV F P7-9
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: F
Previous Run	: 31282	Material	: N/A
Written By	:	Due Date	: 4/30/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.04.12		
Comment	: Est Rev:M 05.09.02 Added D2856-400-720 KJ/JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile & type labels per PPPD350-607-041 CHG006 CL
KS 07.04.17 (1)

2.0	31675A	BASKET BASE ASSEMBLY (350)

Comment: Sub-Component BASKET BASE ASSEMBLY (350)
D2221 B 31675 A
ML 07/05/24

3.0	31675B	350/212/130 BASKET LID

Comment: Sub-Component 350/212/130 BASKET LID
D2512 B 31675 B
ML 07/05/24

4.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick: Assemby Kit

5.0	D2022101	Spacer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	D2022-101	Spacer	M30543

7/5/24 SG

 Form: mprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: _______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:29:00 AM
User: Kim, Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | **Drawing Name:** HELI UTILITY BASKET LH/RH

Job Number: 31675 | **Part Number:** D350607041

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	D2258200	Weight Placard 200lb

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
1	D2258-200	Label	B31104

Seq. #:	Machine Or Operation:	Description :
7.0	D2332041	Lid Prop Assembly 6.69"

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
1	D2332-041	Prop Ass'y	B31105

Seq. #:	Machine Or Operation:	Description :
8.0	D2530	Handle Weldment

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
1	D2530	Handle Weldment	B31106

Seq. #:	Machine Or Operation:	Description :
9.0	D2535	Spring

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	D2535	Spring	M28363

Seq. #:	Machine Or Operation:	Description :
10.0	D2537	Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	D2537	Bushing	B31107

Seq. #:	Machine Or Operation:	Description :
11.0	D27283	Dart Logo label large

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	D2728-3	Label	B22053

7/5/24 S[illegible]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:29:00 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 31675
Part Number: D350607041

Job Number:

Seq. #:	Machine Or Operation:	Description :
12.0	D2931	Bumper

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	D2931	Bumper	B21139

Seq. #:	Machine Or Operation:	Description :
13.0	AN316A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	AN3-16A	Bolt	M103691

Seq. #:	Machine Or Operation:	Description :
14.0	AN47A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	AN4-7A	Bolt	M16149

Seq. #:	Machine Or Operation:	Description :
15.0	AN422A	Bolt

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
1	AN4-22A	Bolt	M100771

Seq. #:	Machine Or Operation:	Description :
16.0	AN424A	Bolt

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
1	AN4-24A	Bolt	M101938

Seq. #:	Machine Or Operation:	Description :
17.0	AN517A	Bolt

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
4	AN5-17A	Bolt	M102140

7/3/24 SQ

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET LH/RH

Job Number: 31675 **Part Number:** D350607041

Job Number:

Seq. #: **Machine Or Operation:** **Description :**

18.0 AN960JD8 Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 AN960JD8 Washer M103585

19.0 AN960JD416 Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 AN960JD416 Washer M103691

20.0 AN960JD416L Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 AN960JD416L Washer M103962

21.0 AN960JD516 Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 AN960JD516 Washer M103641

22.0 AN9704 Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 AN970-4 Washer M103344

23.0 MS20600AD4W3 Cherry Rivets

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 MS20600AD4W3 Rivet M101519

7/5/24 S9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:29:00 AM
User: Kim, Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 31675 | Part Number: D350607041

Job Number:

Seq. #:	Machine Or Operation:	Description :
24.0	MS21042L3	Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 MS21042L3 Nut (or -3) M103641

Seq. #:	Machine Or Operation:	Description :
25.0	MS21042L4	Nut

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 MS21042L4 Nut (or -4) M102532 7/5/24 Sep

Seq. #:	Machine Or Operation:	Description :
26.0	MS21042L5	Nut

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 MS21042L5 Nut (or -5) M102536

Seq. #:	Machine Or Operation:	Description :
27.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D350-607

Seal support gusset seam with white sikaflex-291 Batch: M103497
Expiry date: 10/2007 MJ 07/05/24 X1

Seq. #:	Machine Or Operation:	Description :
28.0	QC5	INSPECT WORK TO CURRENT STEP

J 07-05-24 (1)

Comment: INSPECT WORK TO CURRENT STEP

Seq. #:	Machine Or Operation:	Description :
29.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick: Packing Kit

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:29:00 AM
User: Kim, Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | **Drawing Name:** HELI UTILITY BASKET LH/RH

Job Number: 31675 | **Part Number:** D350607041

Job Number:

Seq. #:	Machine Or Operation:	Description :
30.0	D22301	Mounting Lug

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
4 D2230-1 Lug B30992 X

Seq. #:	Machine Or Operation:	Description :
31.0	D22303	Mounting Lug

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
4 D2230-3 Clamp B30545 X

Seq. #:	Machine Or Operation:	Description :
32.0	D23241	Strut Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
1 *D2324-1 Strut Ass'y B30139 X

Seq. #:	Machine Or Operation:	Description :
33.0	D2856400	Abrasion Strip

Comment: Qty.: 0.6000 f(s)/Unit Total : 0.6000 f(s) X
Pick: Packing Kit
Qty Part Number Description Batch
4 D2856-400-720 Abrasion Strip B30822 X

Seq. #:	Machine Or Operation:	Description :
34.0	AN412A	Bolt

Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
5 AN4-12A Bolt M103947 X

Seq. #:	Machine Or Operation:	Description :
35.0	AN413A	Bolt

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
8 AN4-13A Bolt M103947 X

7/5/24 SP

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ______ **Fault Category:** ________ **NCR:** Yes (No) **DQA:** [signature] **Date:** 07/05/25

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:29:00 AM
User: Kim, Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 31675

Part Number: D350607041

Job Number:

Seq. #:	Machine Or Operation:	Description :
36.0	AN960JD416	Washer

Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
26 AN960JD416 Washer M103691 X

Seq. #:	Machine Or Operation:	Description :
37.0	MS21042L4	Nut

Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
13 MS21042L4 Nut (or -4) M103552 X 7/5/24 SG

Seq. #:	Machine Or Operation:	Description :
38.0	QC4	INSPECT 100% KITS FOR COMPLETENESS

CD 07/05/24 ①

Comment: INSPECT 100% KITS FOR COMPLETENESS 07/05/24 ①

Seq. #:	Machine Or Operation:	Description :
39.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D350-607-041
Location: NEV G 7/8/25 ①

Seq. #:	Machine Or Operation:	Description :
40.0	QC21	FINAL INSPECTION/W/O RELEASE

①

Comment: FINAL INSPECTION/W/O RELEASE 07/05/25

Job Completion

U 07.05.25

Form: rprocess

Dart Aerospace Ltd

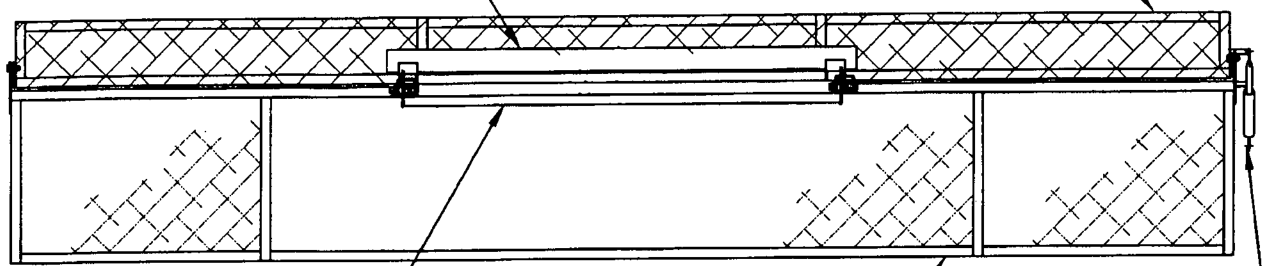
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

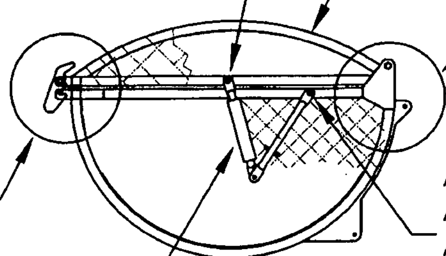
Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

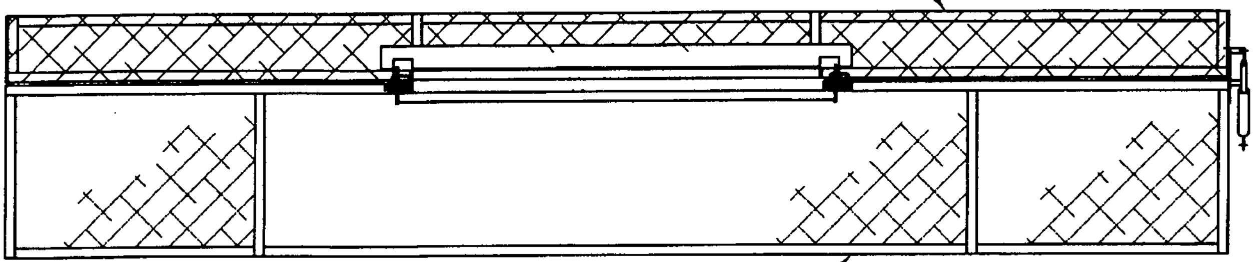
NOTE: Date & initial all entries

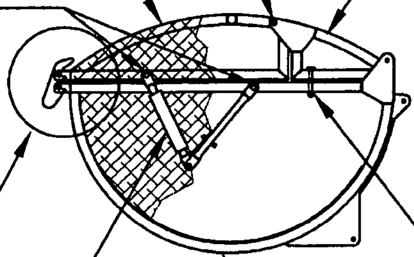




PROP ARM DETAIL
(VIEW C-C)

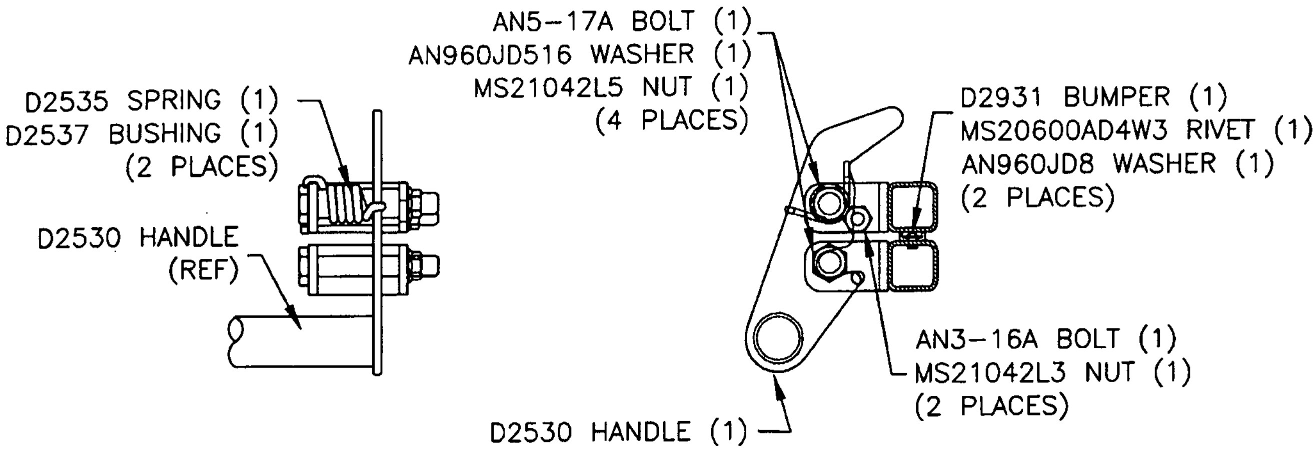
Figure 4 – Basket Replacement Parts
(D350-607-041 Heli-Utility-Basket™)





PROP ARM DETAIL
VIEW C-C

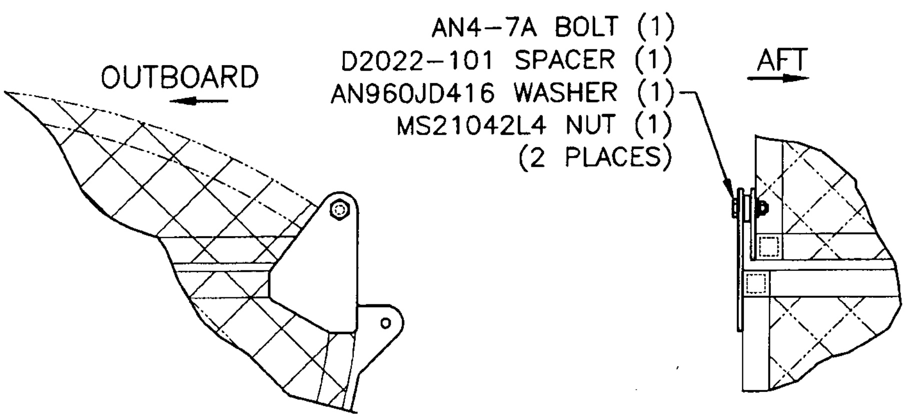
Figure 5– Basket Replacement Parts
(D350-607-043 Heli-Utility-Basket™)



SPRING DETAIL

LATCH DETAIL

DETAIL J:
HANDLE WELDMENT



HINGE DETAIL
END VIEW, LOOKING AFT
OTHER END OPPOSITE

HINGE DETAIL
SIDE VIEW, LOOKING OUTBOARD.
OTHER END OPPOSITE

DETAIL H:
HINGE

Figure 6 – Basket Replacement Parts

Date: Thursday, 4/12/2007 8:29:16 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET BASE ASSEMBLY (350)
Job Number	: 31675A		
Estimate Number	: 10189		
P.O. Number	: N/A	Part Number	: D2221
This Issue	: 4/12/2007 S.O. No. : N/A	Drawing Number	: D2221/D2235
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: F/B1
Previous Run	: 31504C	Material	: N/A
Written By	:	Due Date	: 4/30/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.04.12		
Comment	: Est Rev:J 05.09.02 Added D3442-1 KJ/JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D31661	Basket Hoop

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	D3166-1	RIB	B30825

07/05/17

Seq. #:	Machine Or Operation:	Description :
2.0	D22323	Basket Hinge

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2232-3	Hinge bracket	B30873

07/05/17

Seq. #:	Machine Or Operation:	Description :
3.0	D2325	Support Gusset (350 Bask

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	D2325	Support Gusset	B30546

07/05/17

Seq. #:	Machine Or Operation:	Description :
4.0	D23273	Spacer Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2327-3	Bushing	B31785

07/05/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:29:16 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** BASKET BASE ASSEMBLY (350)

Job Number: 31675A **Part Number:** D2221

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	D2581	Mounting Bracket

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2581	Mounting Bracket	B31189

M 07/05/17

Seq. #:	Machine Or Operation:	Description :
6.0	D34421	Shim

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D3442-1	Shim	B30564

M 07/05/17

Seq. #:	Machine Or Operation:	Description :
7.0	M304EX07516F	Expanded Metal Flat Stai

Comment: Qty.: 41.6745 sf(s)/Unit Total : 41.6745 sf(s)
Pick:

Qty	Part Number	Description	Batch
39.69 sf	M304EX0.75-16F	Expanded Metal	M103840

M 07/05/23

Seq. #:	Machine Or Operation:	Description :
8.0	M304TS0750W065	304 SQ Tube.75x.75x.065W

Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)
Pick:
28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing
Batch: M101937

M 07/05/17

Seq. #:	Machine Or Operation:	Description :
9.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

M 07/05/24

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______ **PAR #:** ______ **Fault Category:** ______ **NCR:** Yes (No) **DQA:** D **Date:** 07/05/25

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:29:16 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** BASKET BASE ASSEMBLY (350)

Job Number: 31675A **Part Number:** D2221

Job Number:

Seq. #:	Machine Or Operation:	Description :
10.0	QC9	VISUAL WELDING INSPECTION
	Comment: VISUAL WELDING INSPECTION	PD 07.05.24 (1)
11.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK	PD 07.05.24 (1)
12.0	POWDER COATING	POWDER COATING
	M103141	
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	07.05.24. (1)
13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	07/05/24
14.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	(1) 07/05/25

Job Completion

07.05.24

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

DART

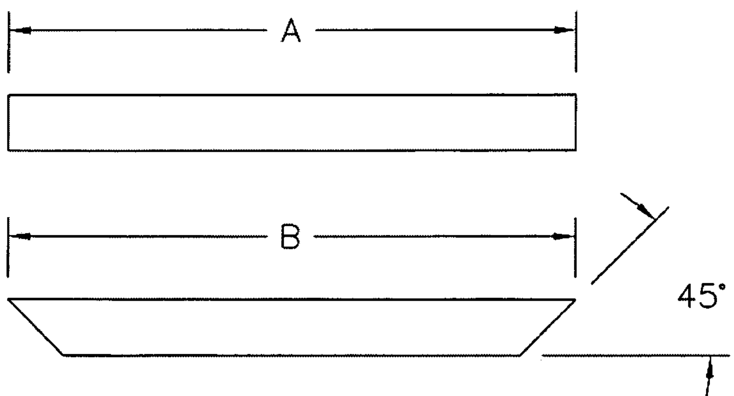
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
BW	PH	
CHECKED	APPROVED	DRAWING NO. D2221 — REV. F — SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350) — SCALE NTS

REV	DATE	DESCRIPTION
C	95.11.21	SEPARATE BASKET AND LID
D	96.06.21	CHANGE LATCH
E	01.04.19	CHANGE HINGE
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS

RELEASED
05.08.19

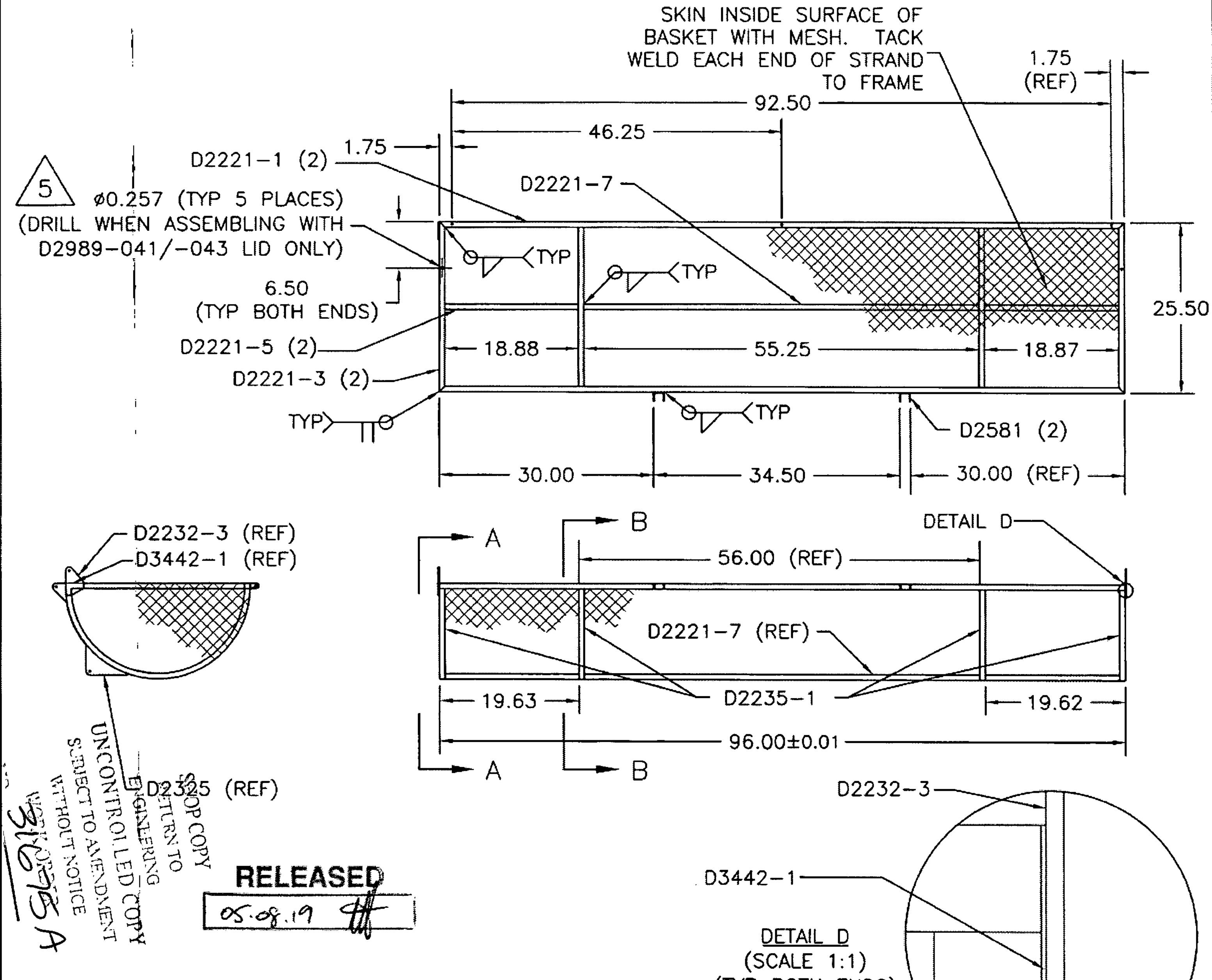
PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	———	96.00	RIB
D2221-3	2	———	25.50	RIB
D2221-5	2	18.88	———	RIB
D2221-7	1	55.25	———	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM



D2221-1/-3/-5/-7

1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
   (REF. DART SPEC M304TS0.750W.060)
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) DRILL Ø0.257 HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH
   D2989-041/-043 BASKET LID



DETAIL D
(SCALE 1:1)
(TYP BOTH ENDS)

D2221 BASKET BASE ASSEMBLY

1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
2) WELD PER DART QSI 004
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

DART

DESIGN	DRAWN BY
BW	PH
CHECKED	APPROVED

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

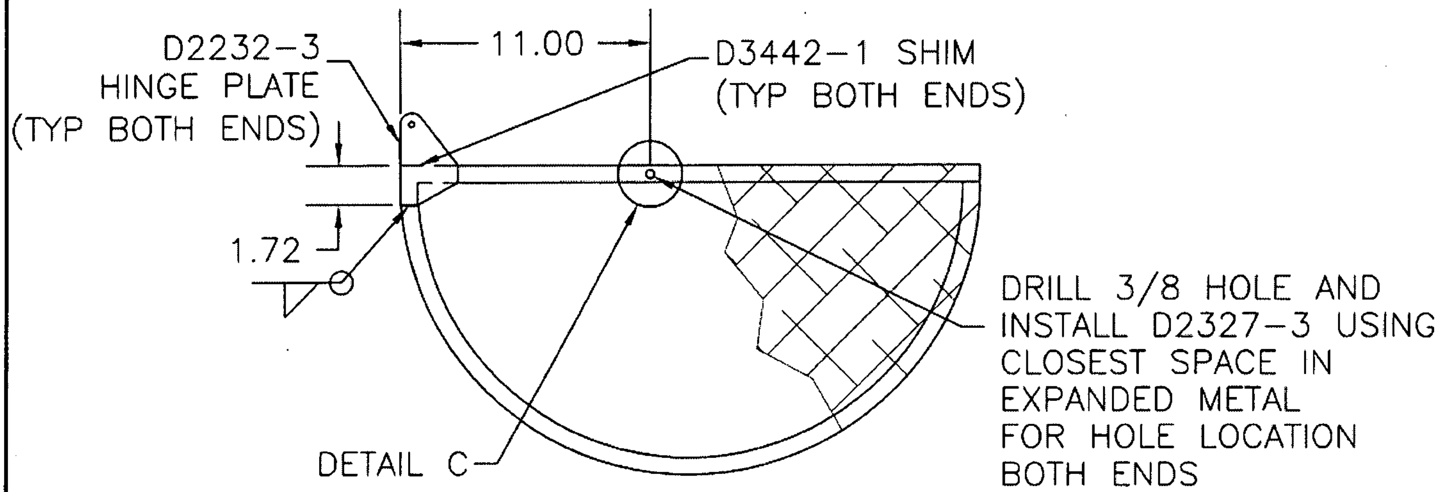
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TITLE: BASKET BASE ASSEMBLY (350)

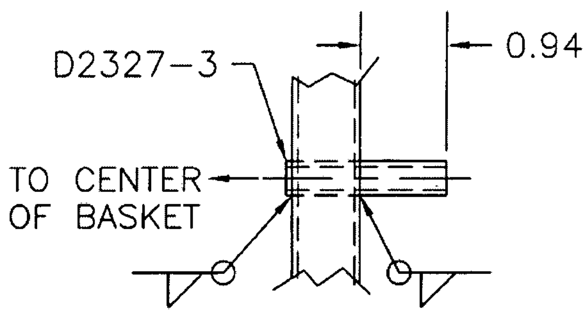
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DART

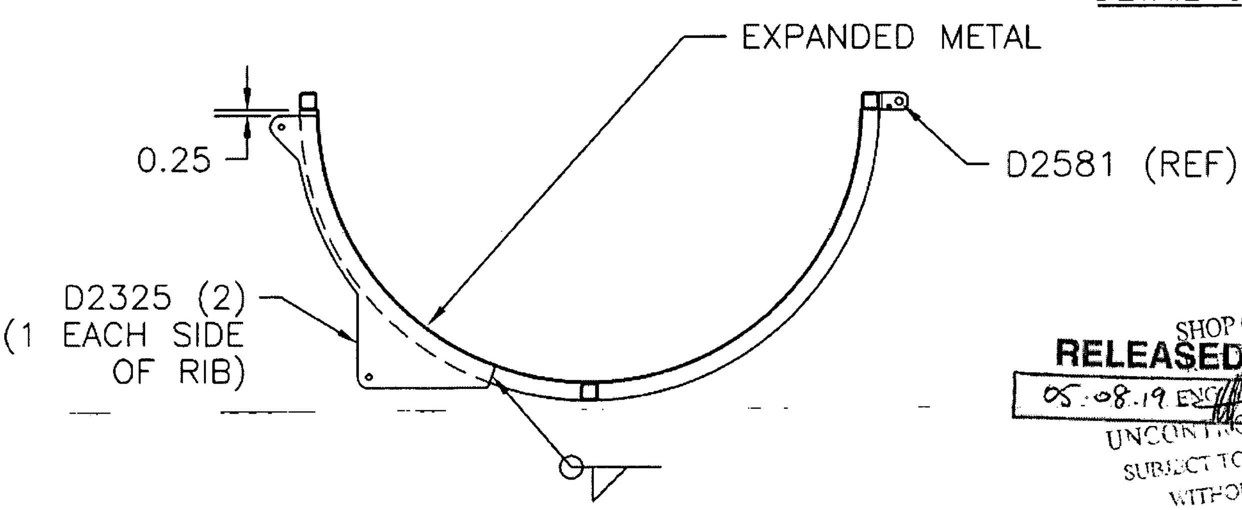
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
BW	PH		
CHECKED	APPROVED	DRAWING NO. D2221	REV. F SHEET 3 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE 1:8



SECTION A-A SAME BOTH END RIBS

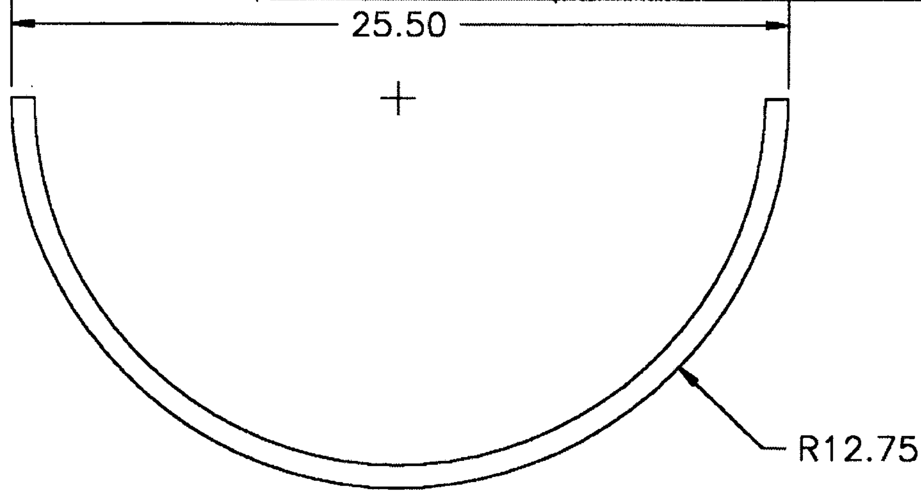


DETAIL C

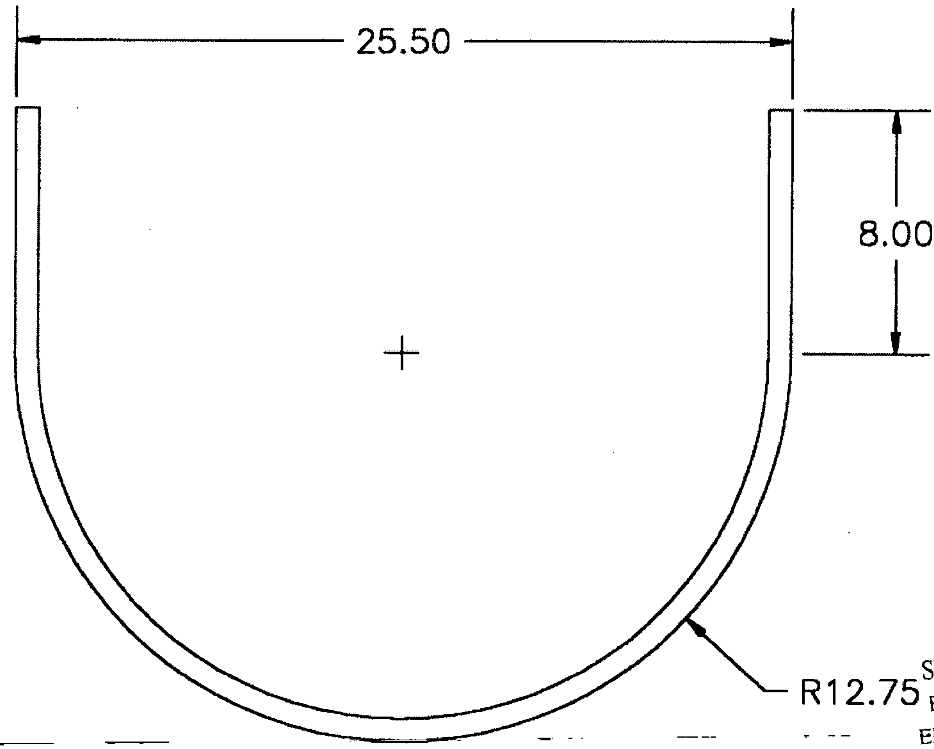


SECTION B-B SAME BOTH CENTER RIBS

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
B WILLIAMS	B WILLIAMS	
CHECKED	APPROVED	DRAWING NO. D2235 — REV. B — SHEET 1 OF 1
DATE 94:12:16		TITLE BASKET RIBS — SCALE
B1	02.08.06	CAN BE MADE FROM D3166-1



D2235-1



D2235-3

CAN BE MADE FROM D3166-1 B1

MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

30858 16675 11A

Dart Aerospace Ltd.

Date: Thursday, 4/12/2007 8:29:29 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350/212/130 BASKET LID
Job Number	: 31675B 9 12		
Estimate Number	: 10193		
P.O. Number	: N/A	Part Number	: D2512
This Issue	: 4/12/2007 S.O. No. : N/A	Drawing Number	: D2512 REV D2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: D2
Previous Run	: 31282B	Material	: N/A
Written By	:	Due Date	: 4/30/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.04.12		
Comment	: Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/RF Est Rev:N 06.04.05 Added level21 EC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W

Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)
Pick:
3/4"x3/4" 304/316 SS tube .063" wall
Batch: M1D19357

M07/05/18

Seq. #:	Machine Or Operation:	Description :
2.0	D31663	Basket Hoop

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3166-3	Basket Hoop	B31118

M07/05/18

Seq. #:	Machine Or Operation:	Description :
3.0	D2506	Placard

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2506	Label Plate	B30548

M07/05/18

Seq. #:	Machine Or Operation:	Description :
4.0	D23271	Spacer Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2327-1	Bushing	B28334

M07/05/18

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: __________________ **PAR #:** ______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 31675B

Part Number: D2512

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	D22321	Hinge

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2232-1	Hinge plate	B29535

M 07/05/18

Seq. #:	Machine Or Operation:	Description :
6.0	D2581	Mounting Bracket

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2581	Mounting Bracket	B31189

M 07/05/18

Seq. #:	Machine Or Operation:	Description :
7.0	M304EX07516F	Expanded Metal Flat Stai

Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)
Pick:

Qty	Part Number	Description	Batch
18 sf	M304EX0.75-16F	Expanded Metal	M103840

M 07/05/22

Seq. #:	Machine Or Operation:	Description :
8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

M 07/05/24

Seq. #:	Machine Or Operation:	Description :
9.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION — PD 07-05-24 (1)

Seq. #:	Machine Or Operation:	Description :
10.0	QC6	DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK — PD 07-05-24 (1)

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______ **PAR #:** ______ **Fault Category:** ______ **NCR:** Yes / No (No circled) **DQA:** [signature] **Date:** 07/05/25

QA: N/C Closed: ______ **Date:** ______

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:29:30 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 350/212/130 BASKET LID

Job Number: 31675B
Part Number: D2512

Job Number:

Seq. #:	Machine Or Operation:	Description :
11.0	POWDER COATING	POWDER COATING

M.103 141

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 07-05-24 ①

Seq. #:	Machine Or Operation:	Description :
12.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

07/05/24 ①

Comment: HAND FINISHING RESOURCE #1
Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4 Batch: M104281

Seq. #:	Machine Or Operation:	Description :
13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION ml 07/05/24

Seq. #:	Machine Or Operation:	Description :
14.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: GA ml 07/05/24

Seq. #:	Machine Or Operation:	Description :
15.0	QC21	FINAL INSPECTION/W/O RELEASE

①

Comment: FINAL INSPECTION/W/O RELEASE 07/05/25

Job Completion

07-05-25

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DESIGN BW	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE NTS

DART

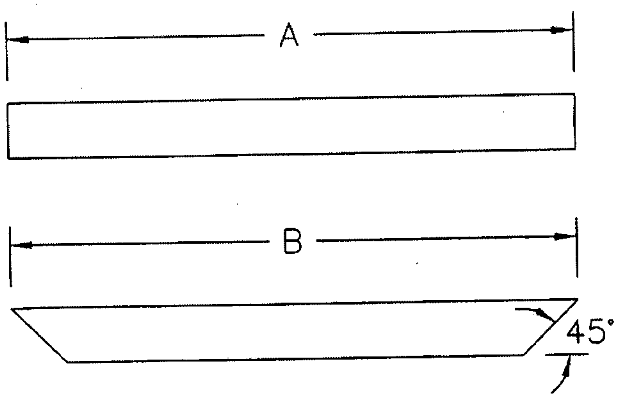
QA COPY ISSUED

RELEASED 01.04.27

REV		DATE	DESCRIPTION
A		95.11.21	NEW ISSUE
B		96.05.24	ADDED LATCH CHANNEL & LABEL PLATE
C		99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074
D		01.04.19	CHANGE HINGE
D1		03 01. 20	ADD D2012-117 FOR D130-701-041
D2		04.09.20	TACK WELD ANTI-SKID AREA

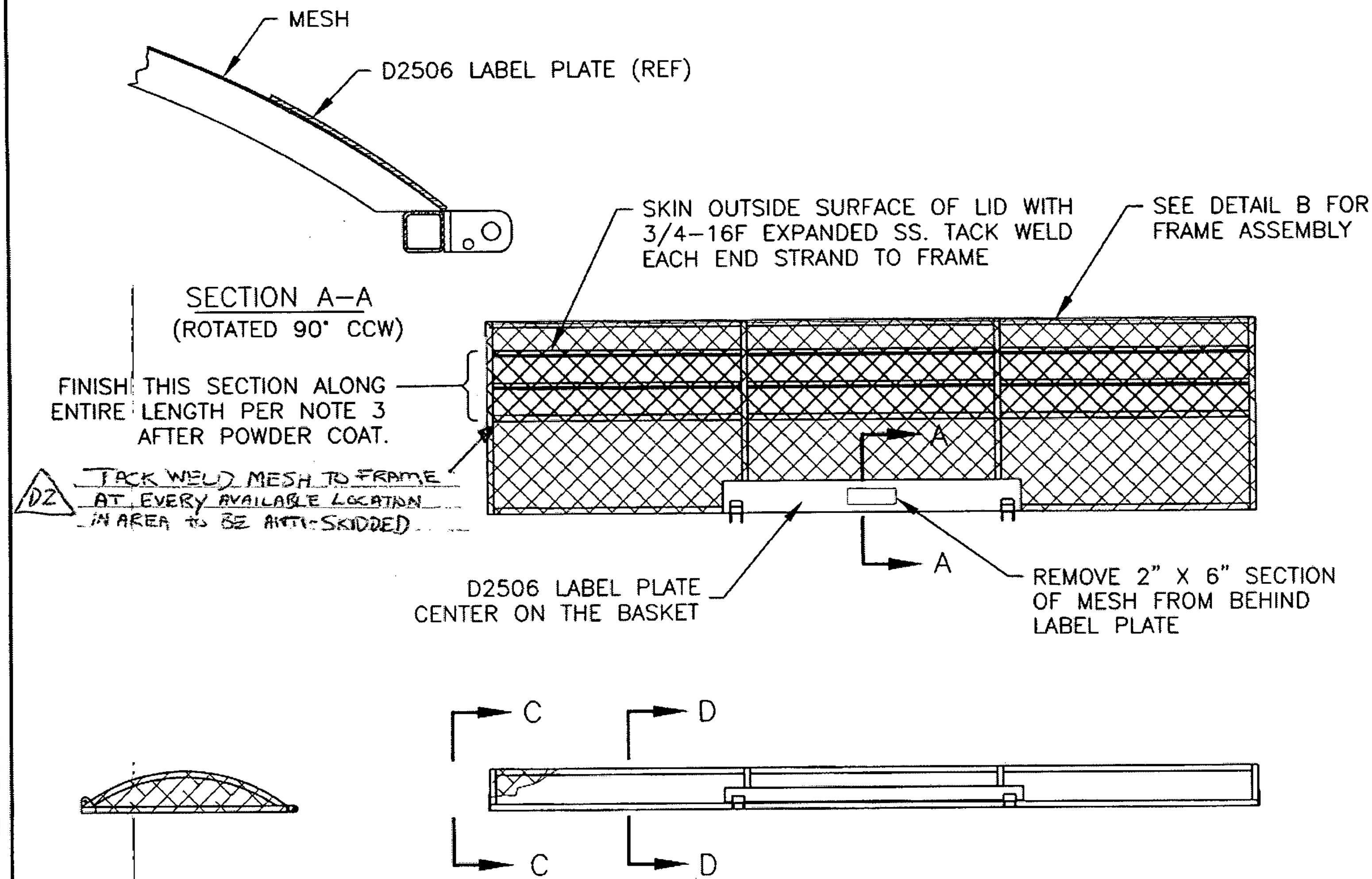
PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	——	25.50	RIB
D2512-3	2	——	95.30	RIB
D2512-5	6	30.84	——	RIB
D2512-7	3	30.63	——	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE ORDER NO. 31675B

D2512-1/-3/-5/-7
CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



SHOP COPY
RETURN TO
ENGINEERING

RELEASED

NO. 3167B

D2512 BASKET LID ASSEMBLY

1) MESH MATERIAL: 3/4-16F EXPANDED SS
2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
3) SPRAY PAINT BLACK INSIDE SURFACE
   APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

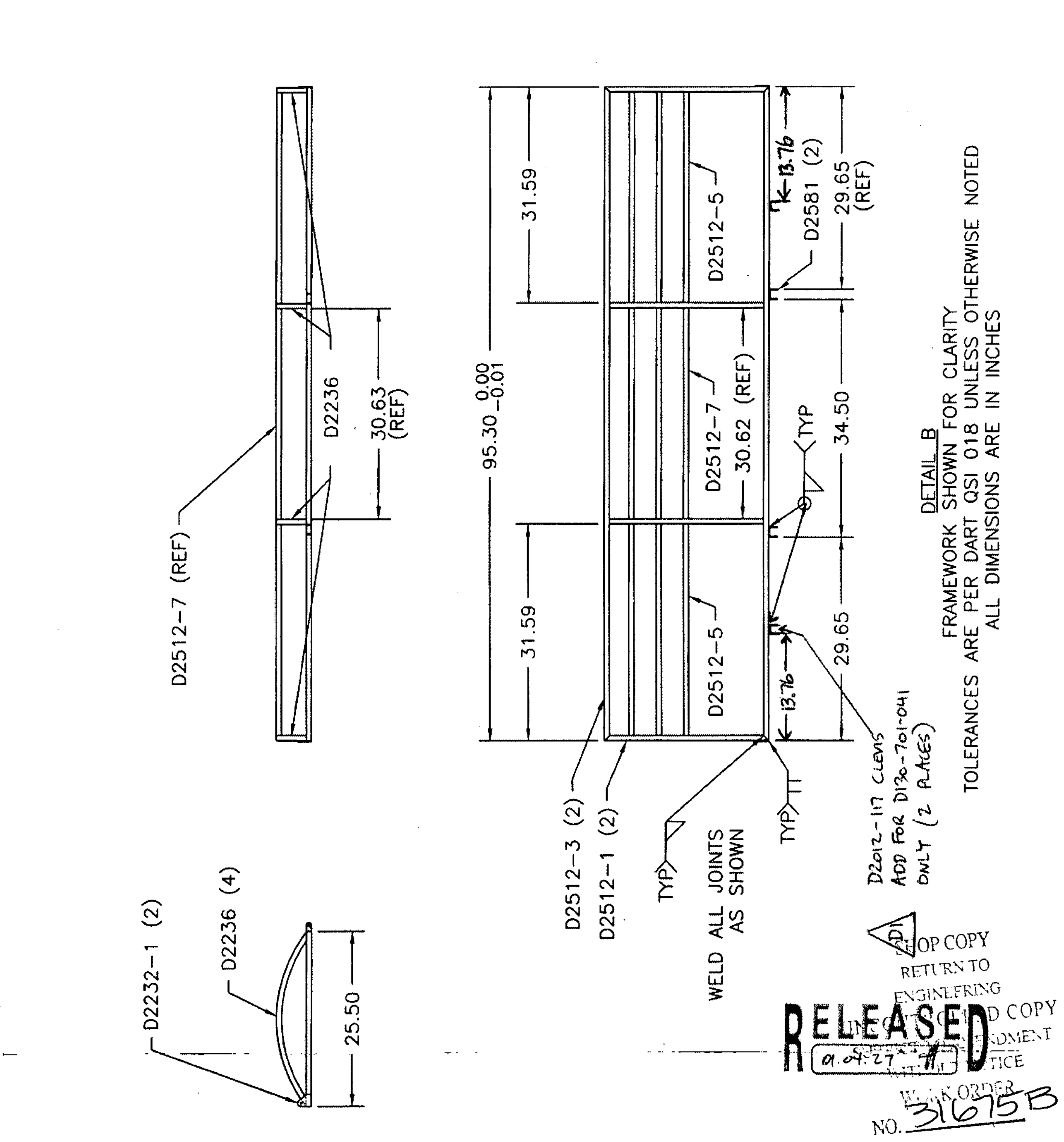
DART

QA COPY ISSUED

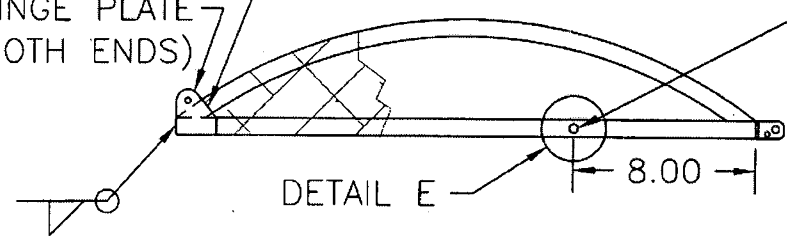
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY	DRAWING NO.	REV.
BW		D2512	D
CHECKED	APPROVED	TITLE	SHEET 2 OF 4
DATE 01.04.19		BASKET LID ASSEMBLY (350/212)	SCALE 1:20

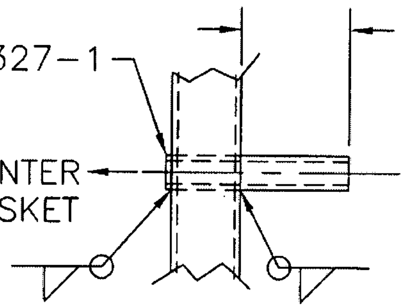
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BW	CP		
CHECKED	APPROVED	DRAWING NO. D2512	REV. D SHEET 3 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:20



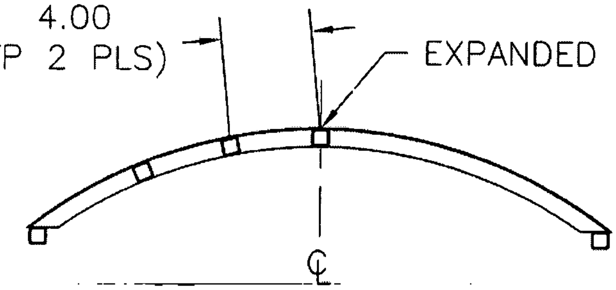
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CHECKED	APPROVED	DRAWING NO. D2512 — REV. D — SHEET 4 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212) — SCALE 1:8



SECTION C-C SIMILIAR BOTH END RIBS



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS